

Work Order ID 64886

December 21, 2010 1:09:39 PM



Page 1

Item ID: D3195-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: umfDate: 10-12-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3195

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (0.75" x 2.00") x 3.60" long

SL 11/6/17

(4)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1 Deburr

SL 11/6/18

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/6/18

(4)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

ant 11/10/18

4

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> H 11/10/18

4

0

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

M 112588

START TIME:

8:35

OVEN TEMPERATURE:

3:20 FINISH TIME:

9:05

H PR 11-01-19.

Powder Coating

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Item ID: D3195-041

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Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

=7 11/10/14

4 6

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface 2-Bond D3195-5 into D3195-1 as per Dwg
D3195 A/R Contact Cement 11/11/095

5/11/07/19 (4)

180

QC5- Inspect part completeness to step on W/O

0.00

8/10/14

QC

Memo

0.00

Quality Control

(74)

Work Order ID 64886

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Item ID: D3195-041

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Setup Start

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Item Name: Bracket Assembly

Start Date: 12/21/10 Start Qty: 4.00

Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>changer 246A</i>	0.00							
									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

11/01/19
MF
11-01-19

Picklist Print

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Page 1

Work Order ID: 64886

Parent Item: D3195-041

Parent Item Name: Bracket Assembly



Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5  Pad		Manufactured	No			100	Each	4.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST042				4					
				51570				4					
M6061T6B0.750X02.00 0.		Purchased	No			170	f	30.5265	0.3	1.263158			
 6061-T6 Bar .750 x 2.00													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT03				30.5265					
				100742				9.5					
				111448				21.0265					

EPB 11/01/19

4

SL 11/01/18

1.3

DART AEROSPACE LTD		Work Order:	64886
Description: Bracket		Part Number:	D3195-1
Inspection Dwg: D3195	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.262	✓		Vern J1-3	
0.242	+/-0.010	.250	✓		"	
1.084	+/-0.010	1.090	✓		"	
R0.200	+/-0.010	.200	✓			
R0.377	+/-0.010	.377	✓			
Ø0.277	+0.005/-0.000	.278	✓		"	
2.677	+/-0.005	2.677	✓		"	
3.432	+/-0.010	3.433	✓		"	
0.754	+/-0.010	.755	✓			
1.387	+/-0.010	1.384	✓			
0.500	+/-0.010	.499	✓			
0.250	+/-0.005	.249	✓			
1.754	+/-0.010	1.757	✓			
Ø0.191	+0.005/-0.000	.192	✓			

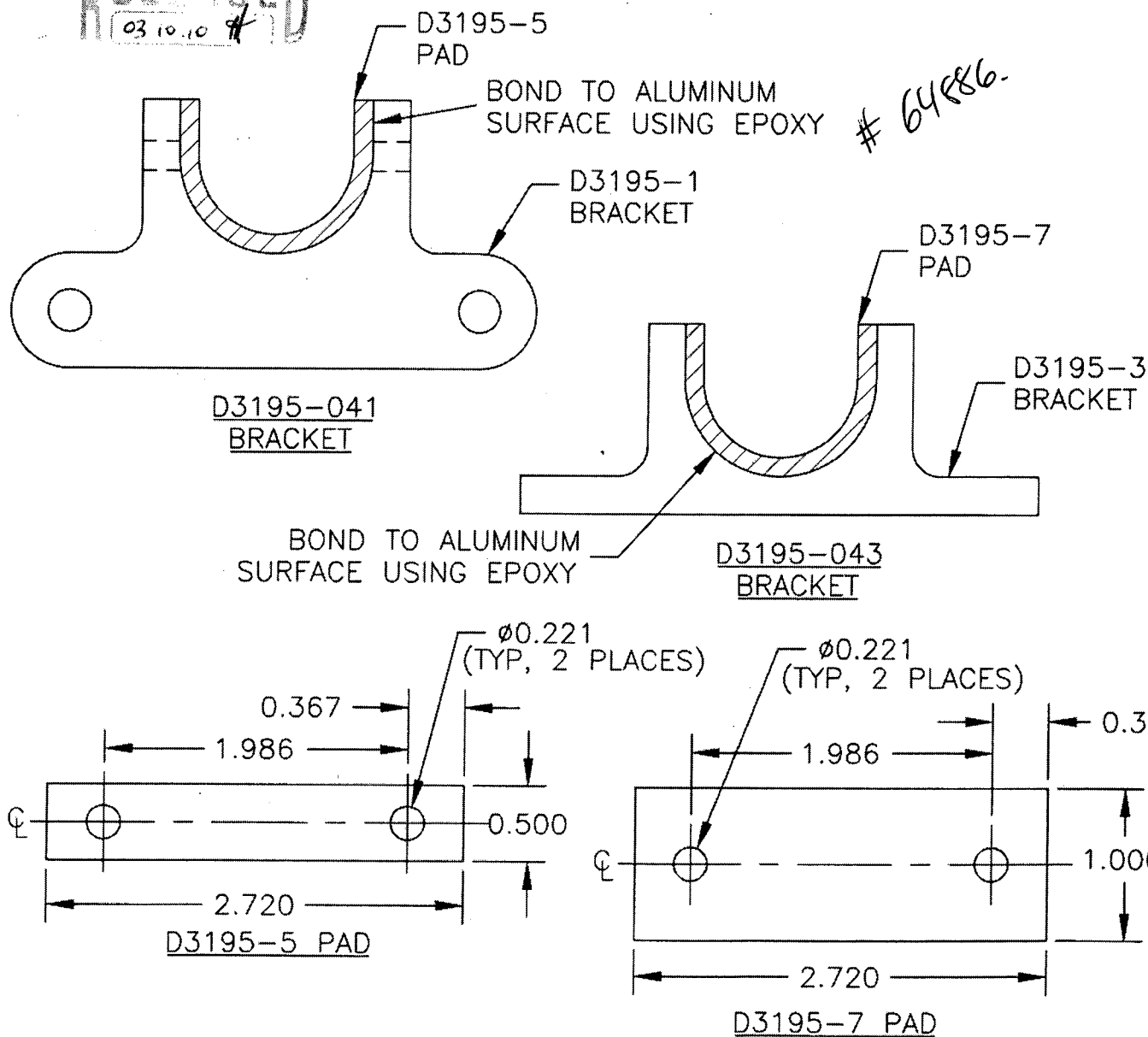
Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11/01/18	Date:	11/01/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-13)	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO.	SHEET 1 OF 3
				D3195	
DATE				TITLE	SCALE
03.06.23				BRACKET	1:1
A	03.06.23			NEW ISSUE	

RELEASED
03.10.10 #10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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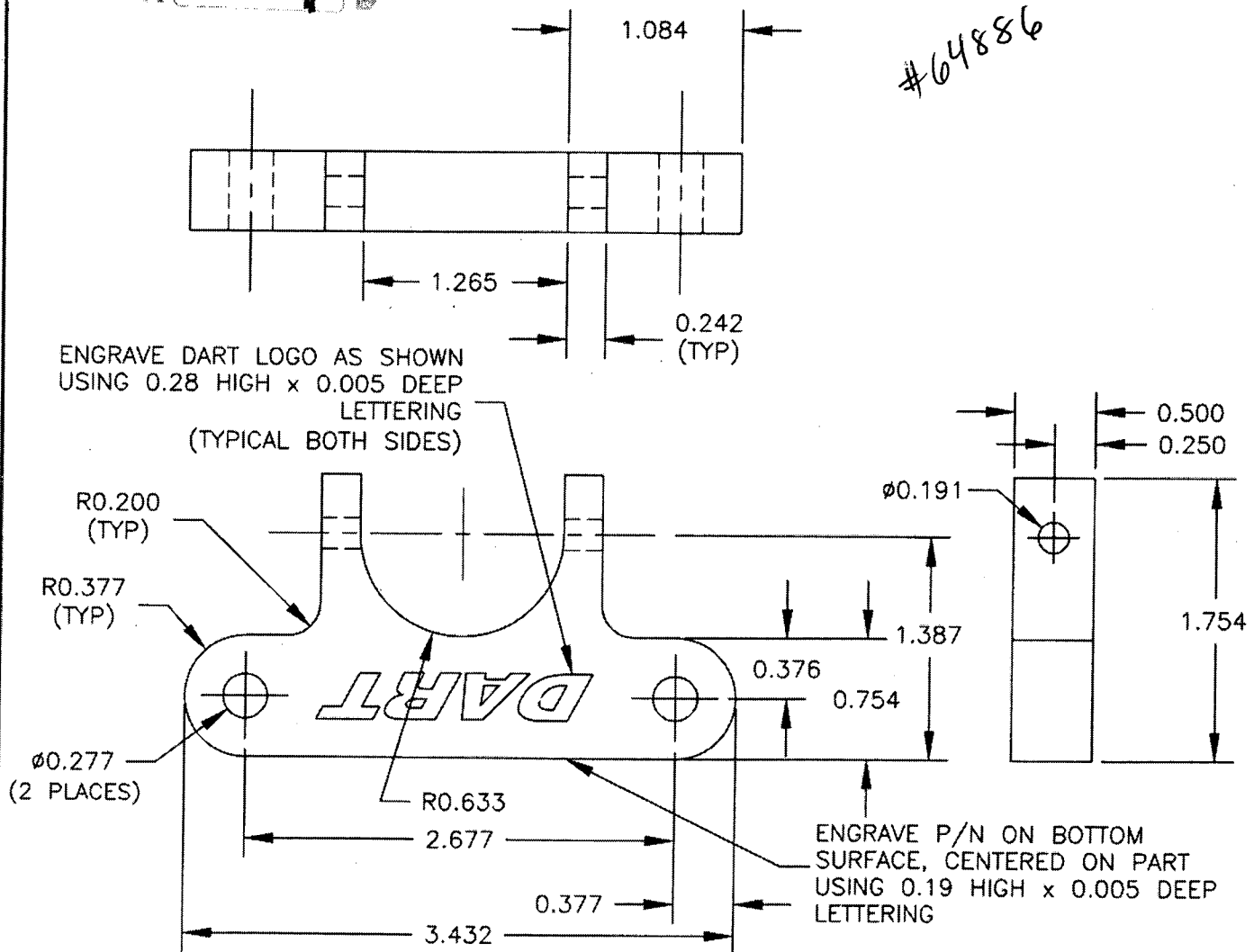
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DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10

#64886



D3195-1 BRACKET

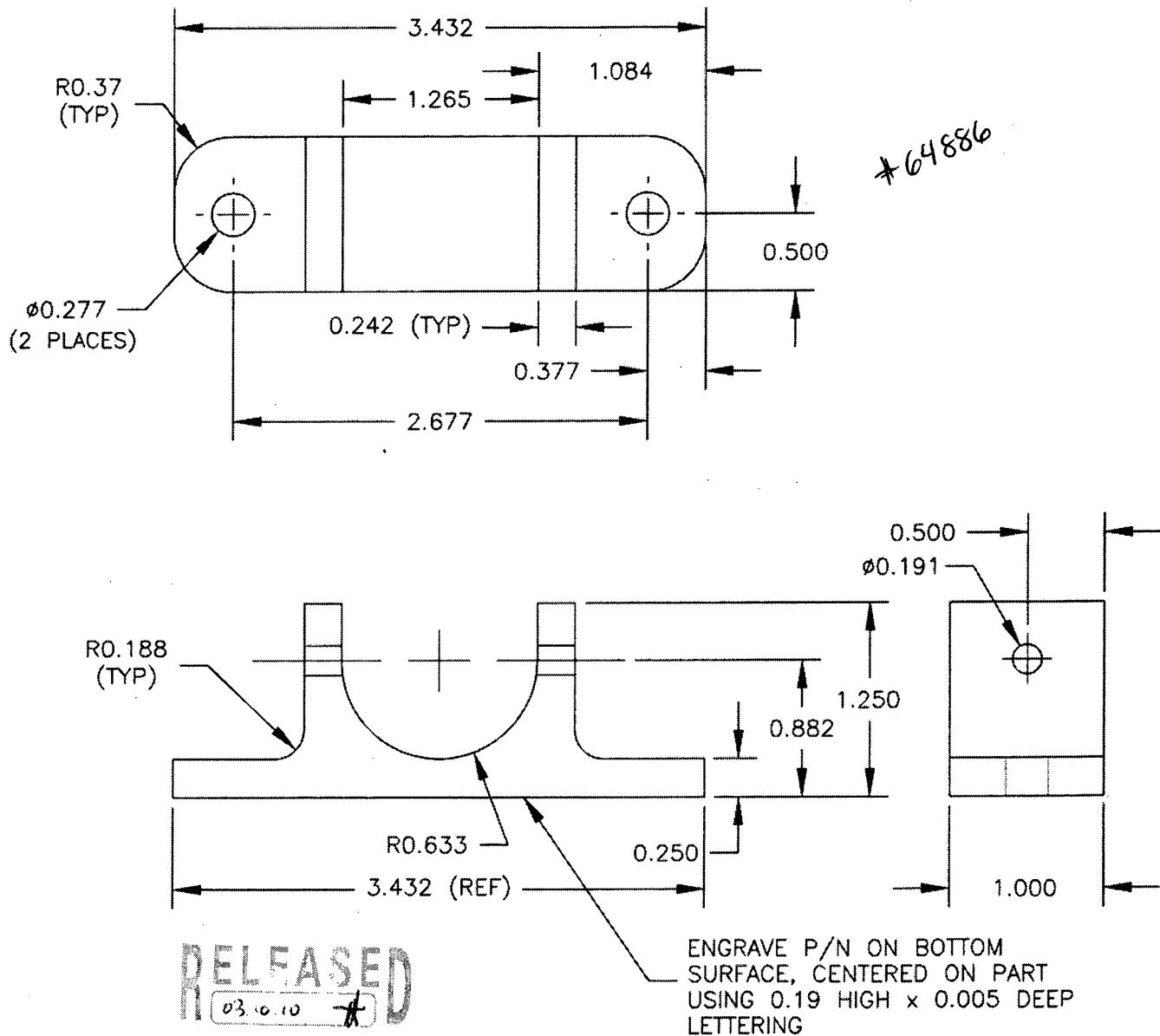
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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